

Date: Monday, 11/6/2006 2:39:27 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L WEB  
 Job Number : 29333  
 Estimate Number : 10722  
 P.O. Number : N/A Part Number : D26547  
 This Issue : 11/6/2006 S.O. No. : N/A Drawing Number : D2654 REV E1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E1  
 Previous Run : 29315 Material : N/A  
 Written By : Due Date : 11/20/2006 Qty: 10 Um: Each  
 Checked & Approved By : 06 11 07  
 Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedure DM  
 Est Rev:e 06.04.05 Added level21 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26007125 Extrusion 'I Beam' thick



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2600-7- 125 Web

B21130

PMC  
 M.H 06/12/01 (10)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

PMC  
 M.H 06/12/01 (10)

(10)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

6/12/2 (10)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PMC

M.H 06/12/02 (10)

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 04/12/21

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 29333

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 6-12-5 10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L-6

Proc M-R 06/12/05 10

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10 RD 06/12/06

Job Completion



U 06/12/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

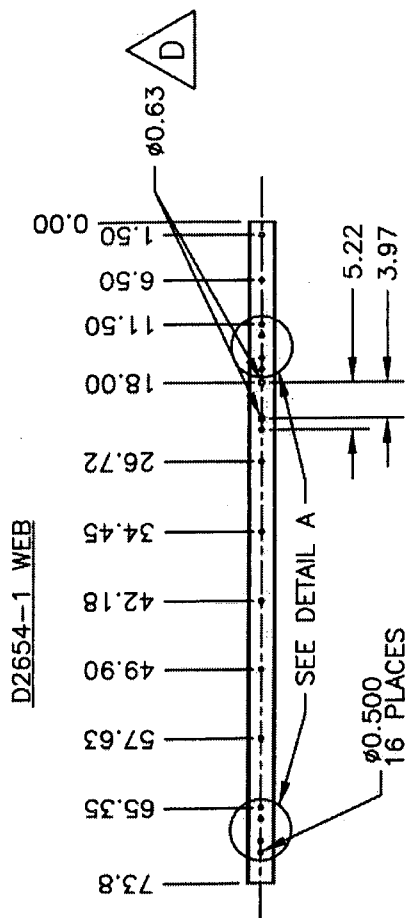
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

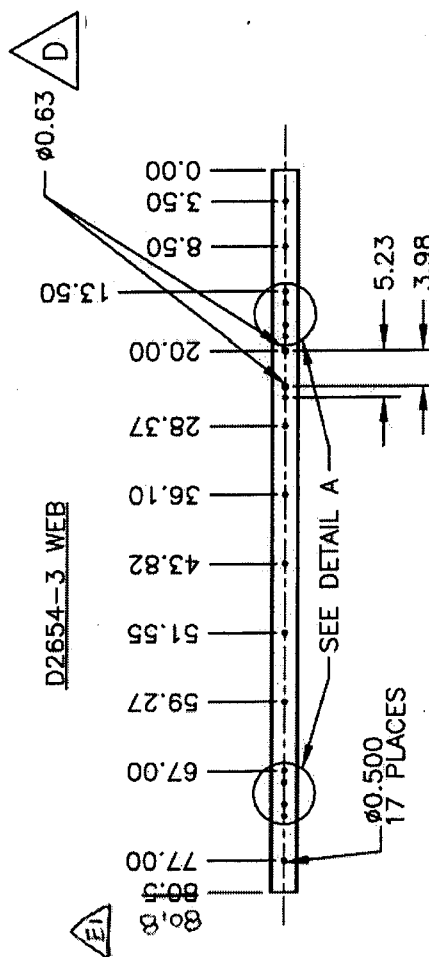
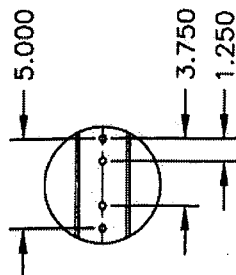


DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>##</i>	APPROVED	<i>##</i>	DRAWING NO.	REV. E
				D2654	SHEET 1 OF 2
DATE			TITLE		SCALE
04.05.26			WEB		1:20
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO Ø0.63		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	<i>CP</i>	<i>##</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5		

RELEASED  
04.06.22



DETAIL A  
SCALE 1:10

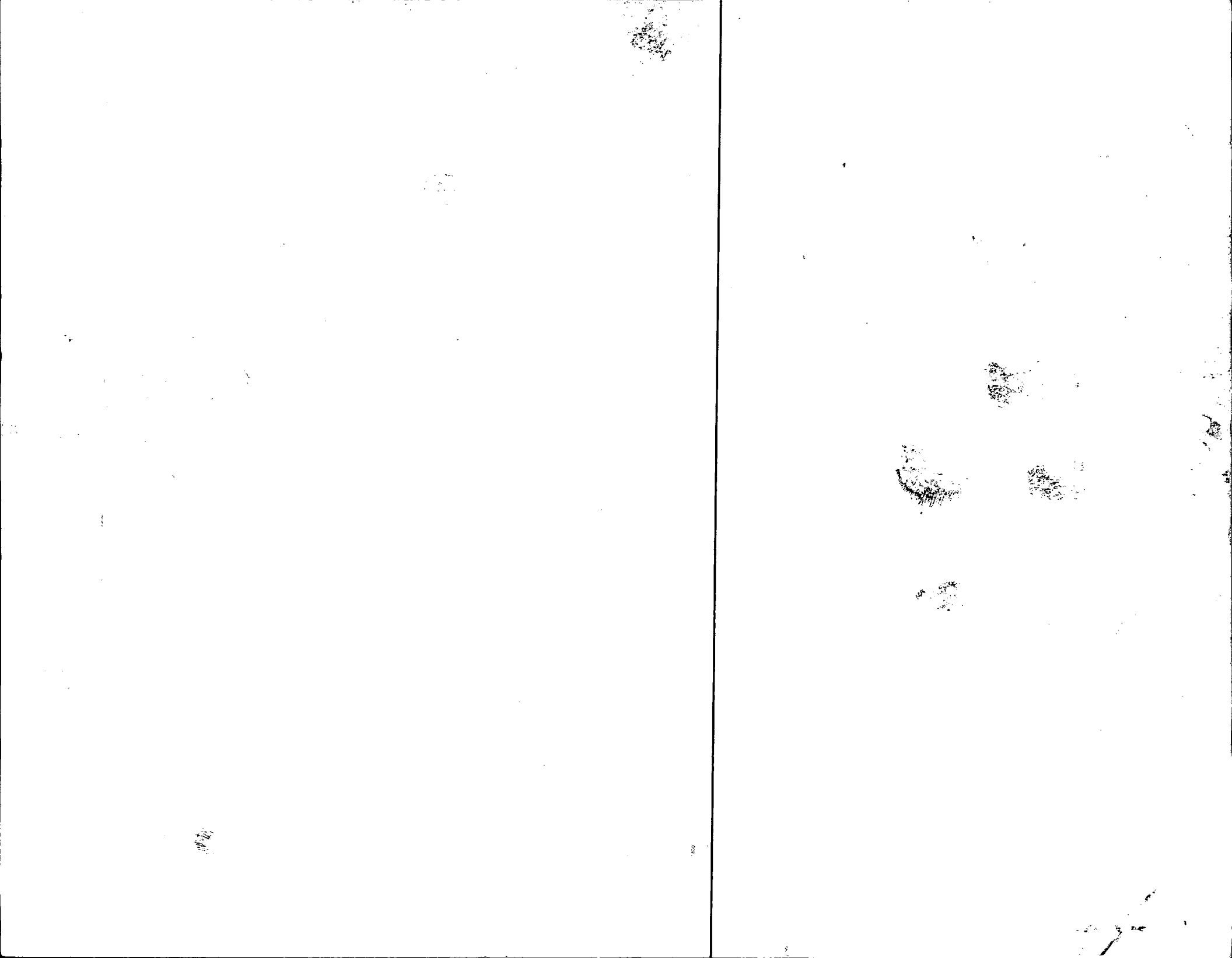


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NO. 29333

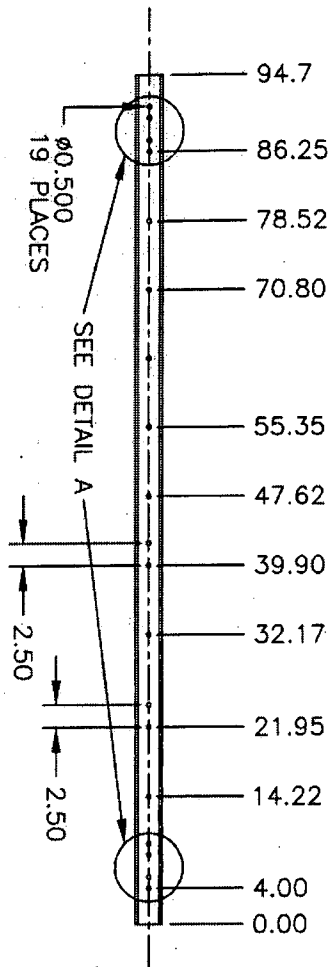
MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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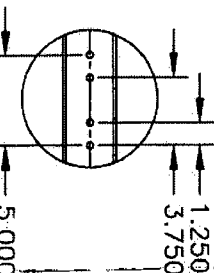
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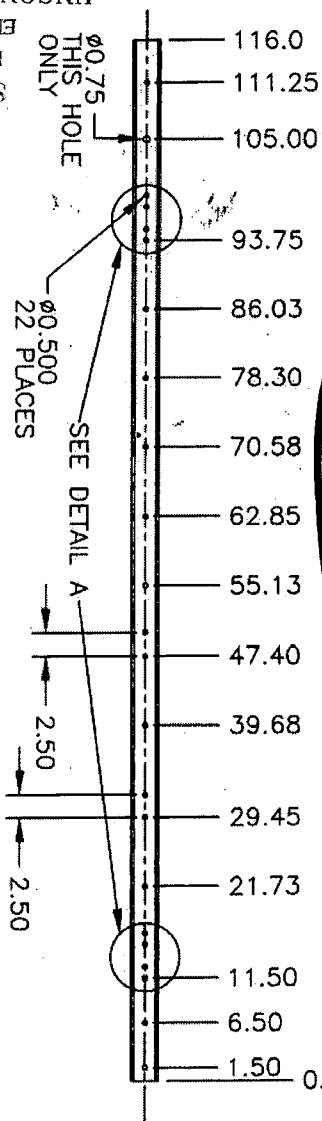
D2654-5 WEB



DETAIL A  
 SCALE 1:10



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
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RELEASED  
 04.06.22

**DART**



DATE 04.05.26	CHECKED 	APPROVED 	DRAWING NO. D2654	SCALE 1:20
DESIGN 	DRAWN BY 	DART Aerospace USA, INC. PORT HADLOCK, WA	REV. E SHEET 2 OF 2	TITLE WEB

